

Date: Thursday, 6/21/2007 2:29:39 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY 25"
Job Number	: 33067		
Estimate Number	: 11190		
P.O. Number	: N/A	Part Number	: D3298001
This Issue	: 6/21/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3298 REV A2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29942	Drawing Revision	: A2
		Material	: N/A
		Due Date	: 7/15/2007
Written By	: <u>JK</u>	Qty:	5 Um: Each
Checked & Approved By	: <u>JK 07.06.22</u>		
Comment	: Est A 04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 10.9373 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-001

Batch: M 103646 x 3 / M 19051 x 2

+1 M103646/M19051

FF 07-07-06

2.0	MS208196D	Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Sleeve

Pick:

Qty	Part Number	Description	Batch
1	MS20819-6D	Sleeve	<u>M103154</u>

FF 07-07-11

3.0	AN8186D	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Coupling Nut

Pick:

Qty	Part Number	Description	Batch
1	AN818-6D	Nut	<u>M103154</u>

FF 07-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: TUBE ASSEMBLY 25"

Job Number: 33067

Part Number: D3298001

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

FF 07-07-11 5 PTO

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

7/7/13 (5x) SQ

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.16


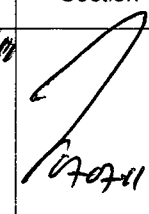

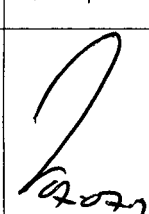
Job Completion



U 07-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3298-001 PAR #: N/A Fault Category: Prod - sm/med fab NCR: Yes No DQA: 1 Date: 07-07-18
 QA: N/C Closed: 1 Date: 07-07-18

NCR: <u>33061</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/11	4	Flaired Tubing before sleeve was put on		Destroy & Replace	07/07/11 FF			

NOTE: Date & initial all entries



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DATE 04.07.06		TITLE TUBE ASSEMBLIES SCALE NTS	
A	04.07.06	NEW ISSUE	
A1	<i>[Signature]</i> 04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	<i>[Signature]</i> 05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

RELEASED
04.04.09 *[Signature]*

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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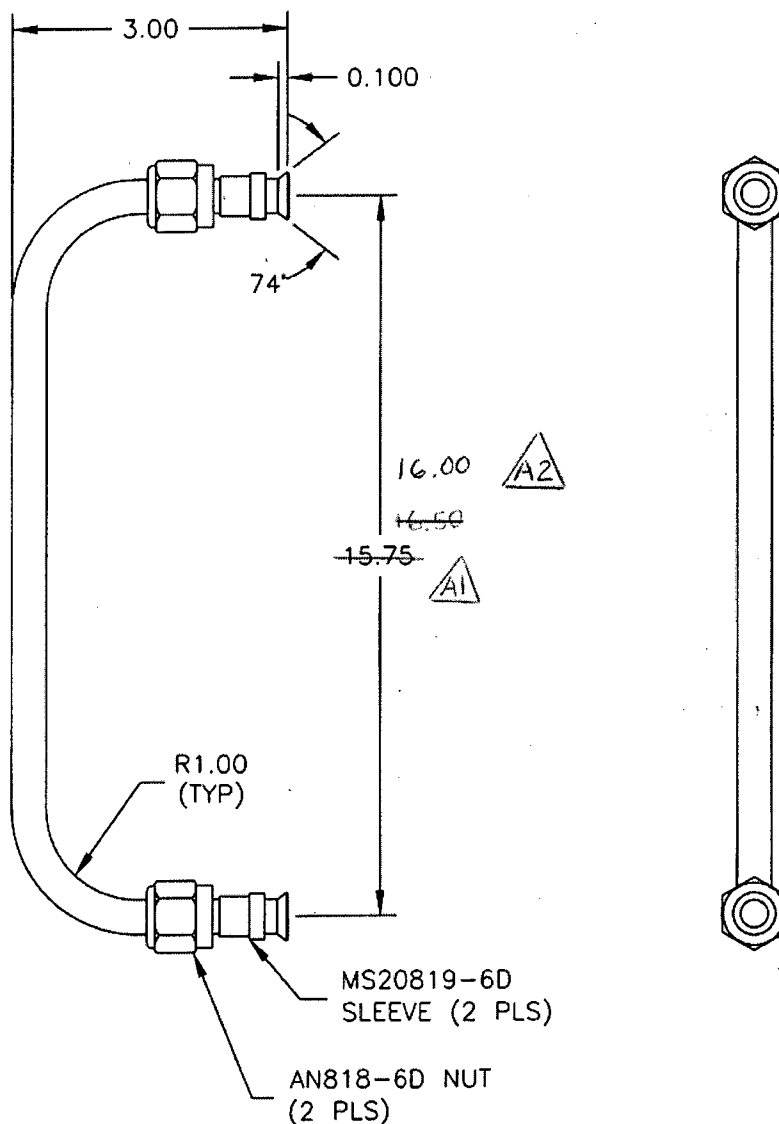
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04.09.09 #



D3298-001

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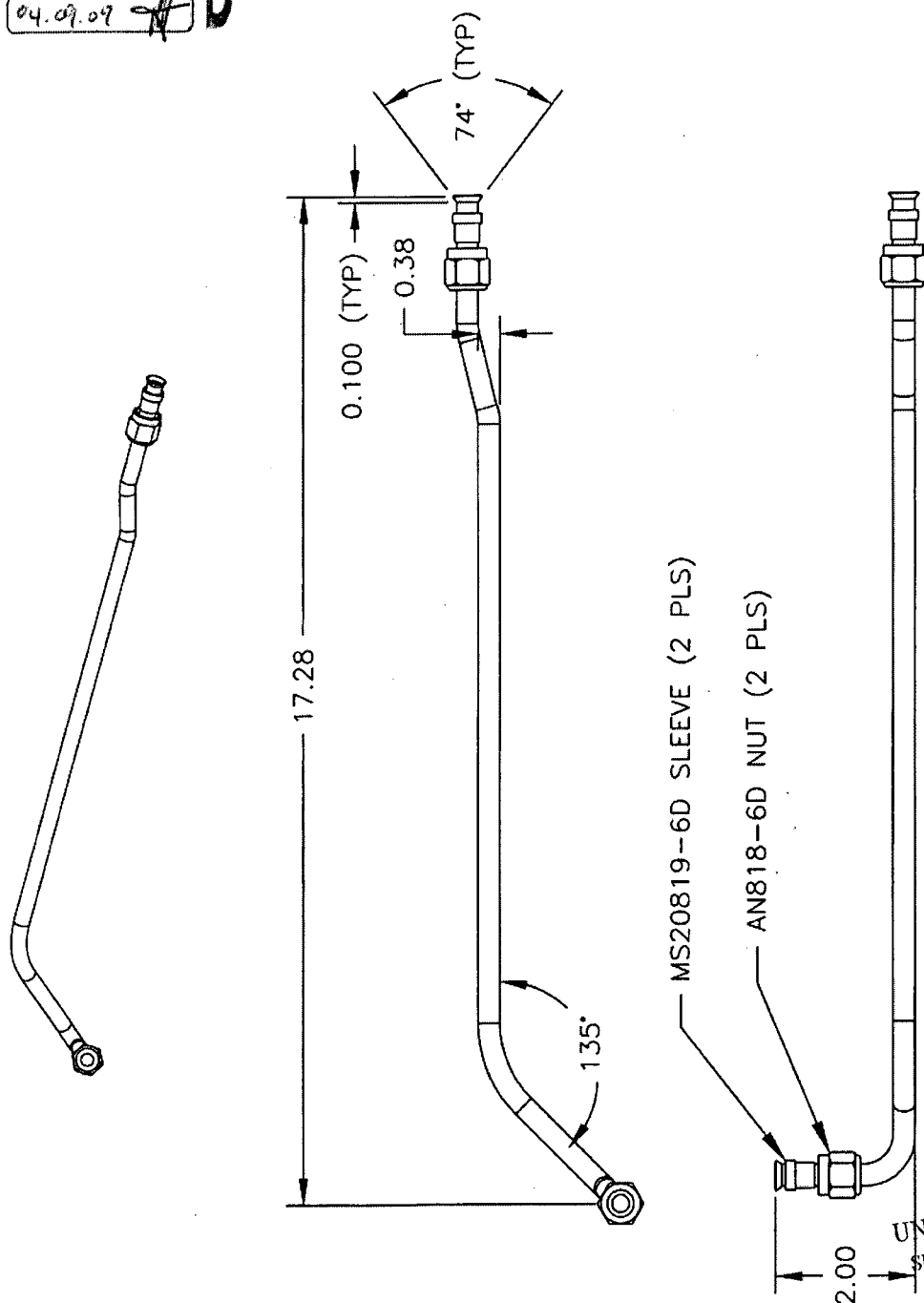
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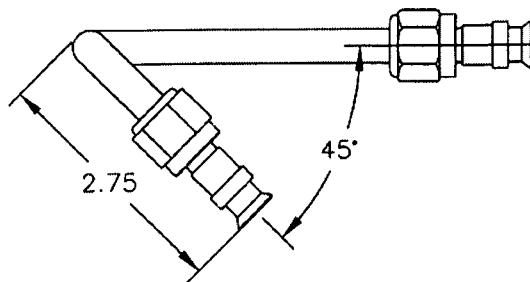
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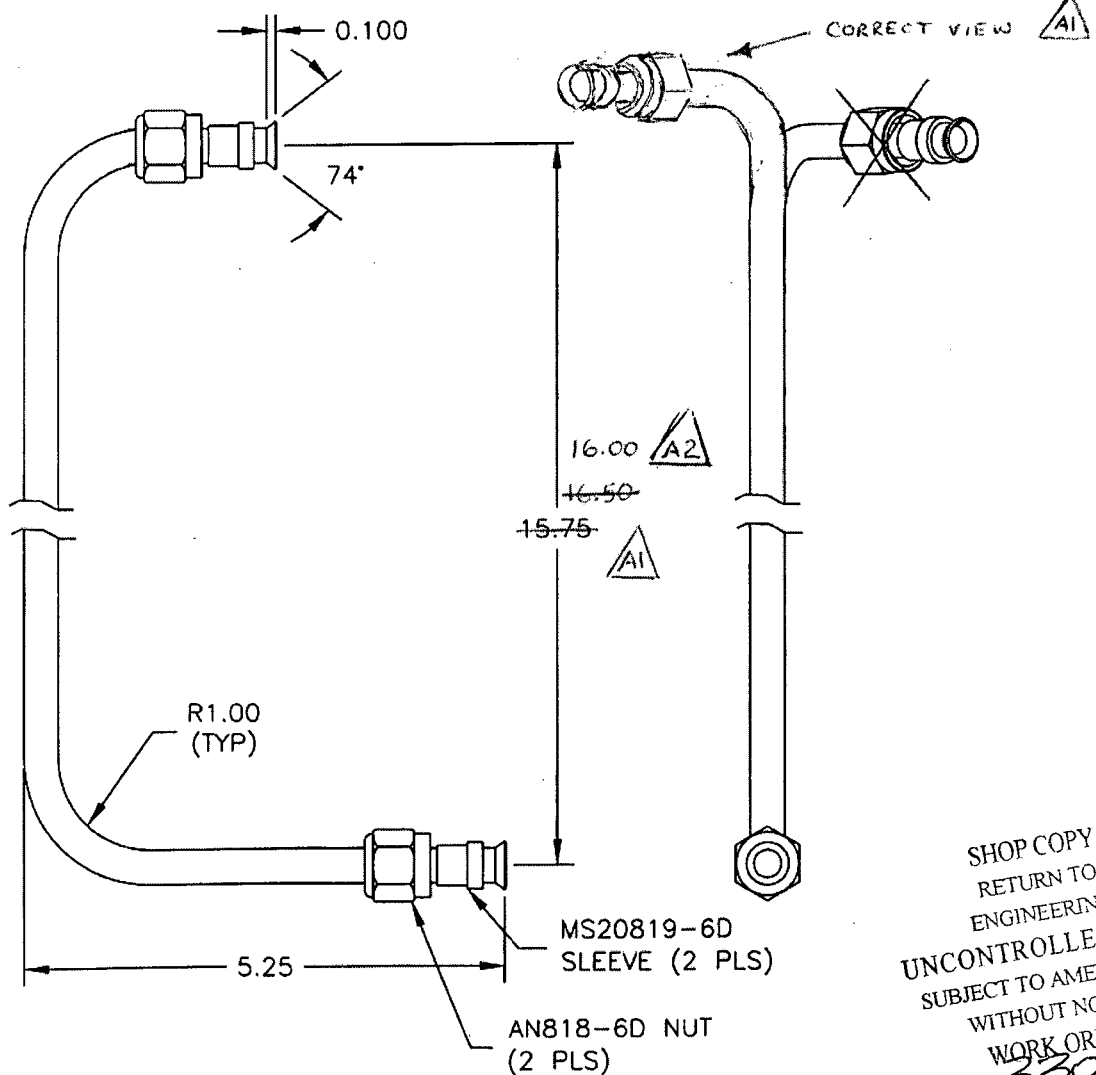


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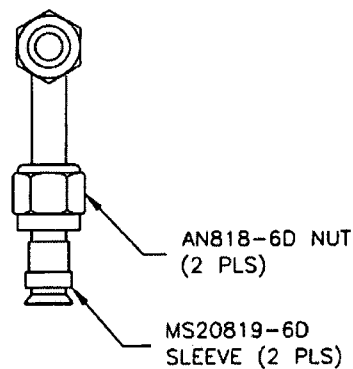
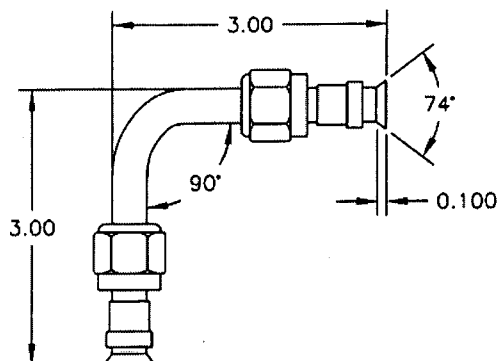
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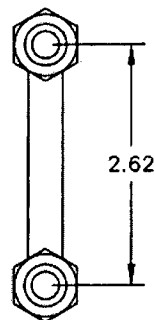
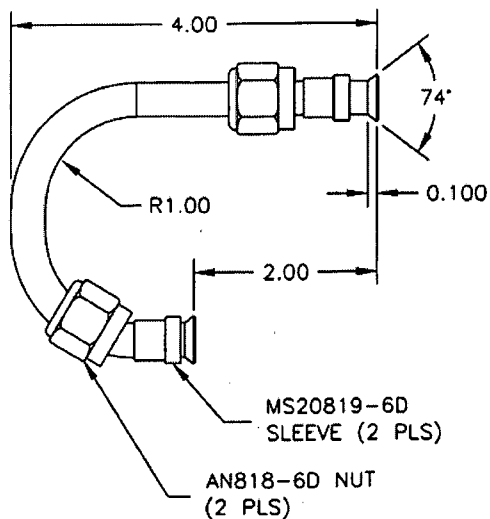


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D3298-013

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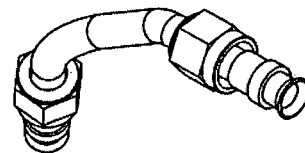
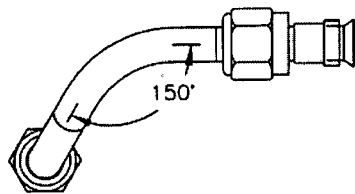
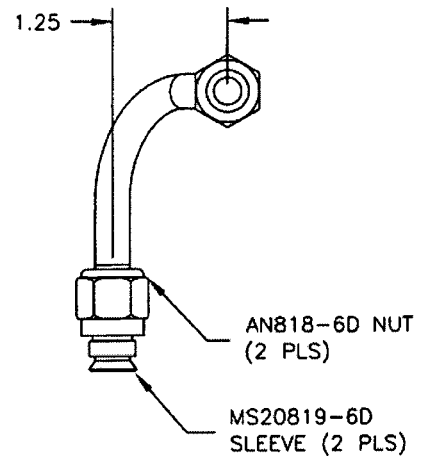
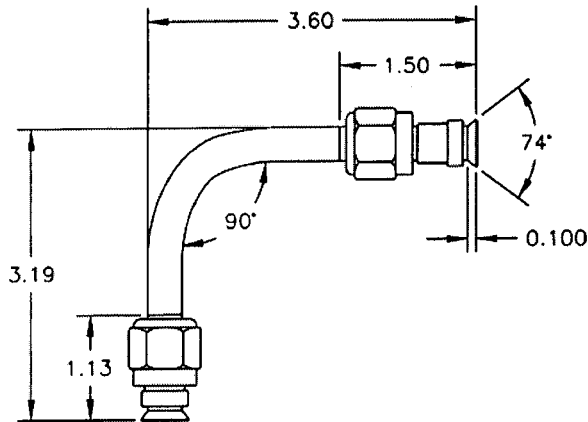
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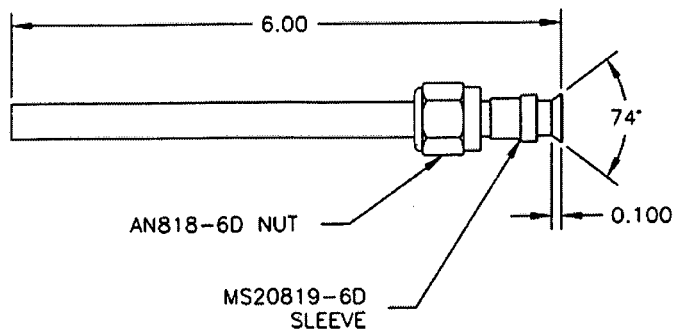


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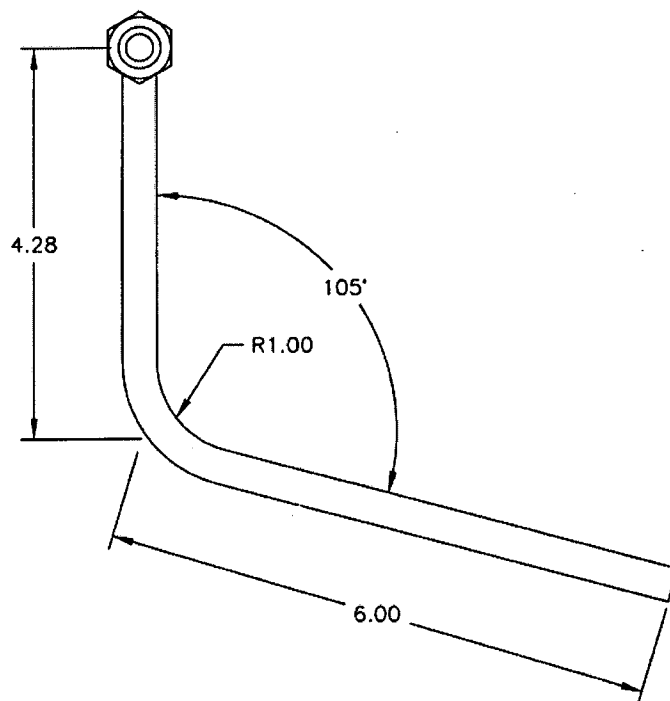
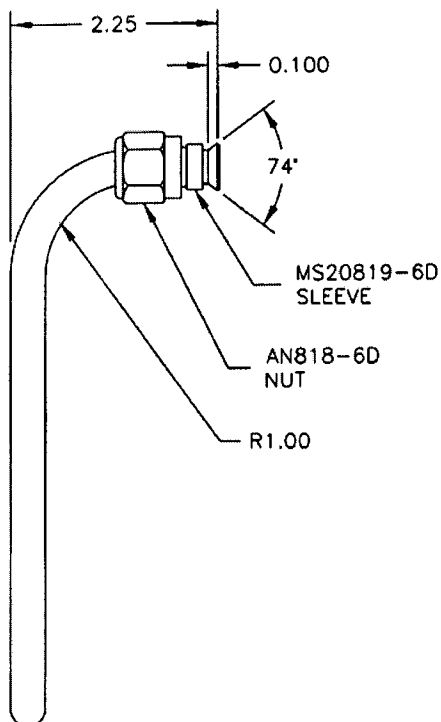
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